

Amendments to the Claims:

The following listing of claims will replace all prior versions, and listings, of claims in the application:

1. (Currently Amended) An insertion-molded cylindrical article, comprising
a cylindrical molded body including a sidewall portion having an inner surface
and an outer surface, defining an upper opening and a lower opening, and an injection gate
mark positioned on said inner surface, and

a sheet-shaped insert having an upper edge and a lower edge that define the
length of the sheet-shaped insert, and the upper edge is below the upper opening of the
cylindrical molded body;

wherein said insert is bonded to said outer surface of said sidewall portion, and
wherein said injection gate mark is positioned, as a result of the injection, at
said inner surface of the cylindrical molded body between said upper and lower edges of said
insert so as to be at a position corresponding to a position on said inner surface that is covered
by said insert, whereby said insert is bonded solely to said outer surface of said sidewall
portion substantially without wrinkles and without injected material on an outer surface of
said insert.

2. (Previously Presented) The insertion-molded cylindrical article set forth in
claim 1, further comprising a gap on said outer surface positioned between opposed ends of
said insert and not covered by said insert,

wherein said injection gate mark is not located in said gap.

3. (Currently Amended) A method for making an insertion-molded cylindrical
article using an insertion injection molding mold,

said insertion-molded article comprising a cylindrical molded body having a
bottom portion, a sidewall portion having a molded body inner surface and a molded body

outer surface, defining an upper opening, and an insert having an upper edge and a lower edge that define the length of the insert, ~~which the upper edge~~ is lower than the upper opening of the cylindrical molded body ~~and a lower edge~~;

said insertion injection molding mold comprising an outer mold unit having an inner surface and a pull-out mold unit and defining a core-inserting space therein, a core having an injection gate opening and shaped to be inserted and fitted into the outer molding unit, and a molding cavity defined between said outer mold unit and said core inside the injection molding mold,

said method comprising:

fitting, attaching and holding said insert along said inner surface of the outer molding unit in said molding cavity,

injecting a molten resin through said injection gate opening, such that the molten resin passes through the injection gate opening in a direction toward said molded body inner surface of the sidewall portion at a position between said upper and lower edges of the insert so as to be at a position corresponding to a position on said molded body inner surface that is covered by said insert so that an injection gate mark is covered by the insert, and

curing and forming the cylindrical molded body while pushing the insert against the inner surface of the outer molding unit with the molten resin, the upper and lower end portions of the cylindrical molded body each defining an opening;

wherein said insert is solely bonded to said molded body outer surface of said sidewall portion of the cylindrical molded body substantially without wrinkles and without injected material on an outer surface of said insert.

4. (Previously Presented) The method set forth in claim 3, wherein said insertion-molded article further comprises a gap on said molded body outer surface of said

sidewall portion positioned between opposed ends of said insert and not covered by said insert;

wherein the insert is fitted, attached and held along said inner surface of the molding cavity, and

wherein the molten resin is not injected toward said gap.

5. (Previously Presented) The method set forth in claim 3, wherein a knock-out pin is provided in the core, said method further comprising:

upwardly pulling out the pull-out mold unit of the outer mold unit after the insertion molding,

cutting a connection between the cured resin inside the injection gate hole and the cylindrical molded body by raising the knock-out pin, and

removing the cylindrical article from the core by pushing the bottom portion of the cylindrical molded body.

6. (Previously Presented) The method set forth in claim 3, wherein the insert is fitted, attached and held in a cylindrical shape along the inner surface of the outer mold unit in the molding cavity by applying a contact frictional force between the core and the insert, said contact frictional force formed by placing the insert into the outer mold unit while the core of the injection molding mold is pulled out from the outer mold unit and the molding cavity is opened, and forwardly moving the core into the outer mold unit.

7-11. (Canceled)

12. (Previously Presented) The method set forth in claim 4, wherein a knock-out pin is provided in the core, said method further comprising:

upwardly pulling out the pull-out mold unit of the outer core mold unit after the injection molding,

cutting a connection between the cured resin inside the injection gate hole and the cylindrical molded body by raising the knock-out pin, and

removing the cylindrical article from the core by pushing the bottom portion of the gate cylindrical molded body.

13. (Previously Presented) The method set forth in claim 4, wherein the insert is fitted, attached and held in a cylindrical shape along the inner surface of the outer mold unit in the molding cavity by applying a contact frictional force between the core and the insert, said contact frictional force formed by placing the insert in the cylindrical shape into the outer mold unit while the core of the injection molding mold is pulled out from the outer mold unit and the molding cavity is opened, and forwardly moving the core into the outer mold unit.

14. (Previously Presented) The method set forth in claim 5, wherein the insert is fitted, attached and held in a cylindrical shape along the inner surface of the outer mold unit in the molding cavity by applying a contact frictional force between the core and the insert, said contact frictional force formed by placing the insert in the cylindrical shape into the outer mold unit while the core of the injection molding mold is pulled out from the outer mold unit and the molding cavity is opened, and forwardly moving the core into the outer mold unit.

15-21. (Canceled)

22. (Previously Presented) The insertion-molded cylindrical article of claim 1, wherein said injection gate mark is positioned only at said inner surface of the sidewall portion while being closer to said upper edge than said lower edge of said insert in an axial direction of the cylindrical article and only at a position corresponding to a position on said inner surface that is covered by said insert.

23. (Previously Presented) The method set forth in claim 3, comprising injecting said molten resin through said injection gate opening, such that the molten resin passes through the injection gate opening in a direction toward said molded body inner surface only

at a position closer to said upper edge than said lower edge of the insert in an axial direction of the cylindrical molded body and only at a position corresponding to a position on said cylindrical molded body inner surface that is covered by said insert.

24-25. (Canceled)

26. (Previously Presented) The insertion-molded cylindrical article set forth in claim 1, wherein said insert is bonded to an entire surface of said outer surface of said sidewall portion, excluding a mouth portion of the cylindrical molded body.

27. (Previously Presented) The method set forth in claim 3, wherein said insert is bonded to an entire surface of said outer surface of said sidewall portion, excluding a mouth portion of the cylindrical molded body.

28. (Currently Amended) An insertion-molded cylindrical article made by an insertion injection molding mold,

said insertion-molded article comprising a cylindrical molded body having a bottom portion, a sidewall portion having a molded body inner surface and a molded body outer surface, defining an upper opening, upper and lower end portions, and an insert having an upper edge and a lower edge that define the length of the insert, which the upper edge is lower than the upper opening of the cylindrical molded body ~~and a lower edge;~~

said insertion injection molding mold comprising an outer mold unit having an inner surface and a pull-out mold unit and defining a core-inserting space therein, a core having an injection gate opening and shaped to be inserted and fitted into the outer molding unit, and a molding cavity defined between said outer mold unit and said core inside the injection molding mold,

the article being made by a method comprising:

fitting, attaching and holding said insert along said inner surface of the outer molding unit in said molding cavity,

injecting a molten resin through said injection gate opening, such that the molten resin passes through the injection gate opening in a direction toward said molded body inner surface of the sidewall portion at a position between said upper and lower edges of the insert so as to be at a position corresponding to a position on said molded body inner surface that is covered by said insert so that an injection gate mark is covered by the insert, and

curing and forming the cylindrical molded body while pushing the insert against the inner surface of the outer molding unit with the molten resin, the upper and lower end portions of the cylindrical molded body each defining an opening,

wherein said insert is solely bonded to said molded body outer surface of said sidewall portion of the cylindrical molded body substantially without wrinkles and without injected material on an outer surface of said insert.

29. (Previously Presented) The method set forth in claim 5, wherein the injection gate mark is formed by said step of cutting a connection between the cured resin inside the injection gate hole and the cylindrical molded body.

30. (Currently Amended) An insertion-molded cylindrical article comprising:
a cylindrical molded body including a sidewall portion having an inner surface and an outer surface, defining an upper opening, and an injection gate mark positioned on said inner surface, and

a sheet-shaped insert having an upper edge and a lower edge that define the length of the sheet-shaped insert, and the upper edge is below the upper opening of the cylindrical molded body;

wherein said insert is bonded to said outer surface of said sidewall portion,

wherein said injection gate mark is positioned, as a result of the injection, at said inner surface of the cylindrical molded body between said upper and lower edges of said

insert so as to be at a position corresponding to a position on said inner surface that is covered by said insert,

wherein the article is formed in an insertion injection mold which includes an outer mold unit having an inner surface and a pull-out mold unit and defining a core-inserting space therein, a core having an injection gate opening and a knock-out pin and shaped to be inserted and fitted into the outer molding unit, and a molding cavity defined between said outer mold unit and said core inside the injection molding mold,

where the article is made from a method comprising;

fitting, attaching and holding said insert along said inner surface of the outer molding unit in said molding cavity,

injecting a molten resin through said injection gate opening, such that the molten resin passes through the injection gate opening in a direction toward said molded body inner surface of the sidewall portion at a position between said upper and lower edges of the insert so as to be at a position corresponding to a position on said molded body inner surface that is covered by said insert so that the injection gate mark is covered by the insert, and

curing and forming the cylindrical molded body while pushing the insert against the inner surface of the outer molding unit with the molten resin,

upwardly pulling out the pull-out mold unit of the outer mold unit after the insertion molding,

cutting a connection between the cured resin inside the injection gate hole and the cylindrical molded body by raising the knock-out pin, thereby forming the injection gate mark on the inner surface of sidewall portion of the cylindrical molded body, and

removing the cylindrical article from the core by pushing the bottom portion of the cylindrical molded body.

31. (New) The method set forth in claim 3, wherein said injection gate opening is tapered-like thinned and proceeds downward at an angle.

32. (New) The insertion-molded cylindrical article made by the insertion injection molding mold set forth in claim 28, wherein said injection gate opening is tapered-like thinned and proceeds downward at an angle.

33. (New) The insertion-molded cylindrical article set forth in claim 30, wherein said injection gate opening is tapered-like thinned and proceeds downward at an angle.